Quality Control



Page 1

February 9, 201	0 1:25:30 P	M										
Item ID: Revision ID:	K607-041			Accept				S	Setup			
Item Name:	Kit Basket D	350-607-041								Stop		
Start Date: Required Date:	2/09/10 2/15/10	Start Qty: 1.00 Req'd Qty: 1.00	100 100 100 100 100 100 100 100 100		Cust Item II Customer:	D:						
Reference:												
Approvals:	Process Pl	an:	Date: 10-2-09			ite:		F	Run	Start Stop		
	QC:	`	Date:	SPC (Y/N):	Da	ite:						
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reje Qty		eject lumber	Insp. Stamp
Draw Nbr	Re	vision Nbr										
IIN-D350-607	F											
100 		DOCUMENT CONTR		0.00	[_]_	-		+	For	MF	101	02/17
Document Control		Create Wh	ite labels per PPP K607-041	CHG008 💍 .to	laliz							
		Pick Kit		0.00				10.	- と・	16	SZ	1 (1)
Packaging		Memo		0.00						<u>· </u>		
Packaging				·								
		QC4- 100% Inspect kit	ts for completeness	0.00 Calo	را							
QC		Memo		0.00	いて			(\mathcal{H})				

Dart Ae	rospa	ce Ltd
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	•								
W/O:			WC	RK ORDER CHANG	GES			, .	r
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									!
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	\:	_ Date: _	
		olution:							
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCF	R)			***************************************
DATE	STEP	Description of NC			ction B	Verific	ation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector
									-
									•

Work Order ID 56059

Page 2

February 9, 2010 1:25:30 PM

Item ID:

K607-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Kit Basket D350-607-041

Start Date: Required Date: 2/15/10

2/09/10

Start Qty: 1.00

Req'd Qty: 1.00



Identify and pack for shipping as per PPP K607-041 Location:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Run Start

Reject

Qty

Stop

Sequence ID/

Operation Work Center ID Description

QC:

Date:

Set Up/ **Run Hours** Draw Number Draw Rev.

Date:

Plan Code

Accept Qty

Reject

Insp. Number Stamp

130

Packaging

Packaging

0.00

0.00

10-2-17

140

Packaging

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

Memo

0.00

Dart Aerospace Ltd

	•								,
W/O:			WC	RK ORDER CHANG	ES			, 1	•
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date (Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,					
Part No		PAR #:							
_	Res	solution:	Disposition	n:	_ QA: N/C Clo	sed:		_ Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR				
DATE	STEP	Description of NC		Corrective Action Section		Verificat	ion	Approval	Approvai
	Jier	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector

Picklist Print

February 9, 2010 1:25:34 PM

Work Order ID: 56059

Parent Item:

K607-041

Parent Item Name:

Kit Basket D350-607-041

Comments:

IPP RevA: New issue DD verified by:EC



Start Date: 2/09/10

Required Date: 2/15/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
D2230-1		Manufactured	No				Each	140.0000	/4.0000 	-2-16	s)	

Lug

<u>Warehouse</u>		Loc Qty	Loc Code	
Location				
Main Warehouse				
ST		4		
51761	1.5	4		
Main Warehouse				
ST476		136		4
54755		136		4
		Fach	13 0000 4 0000	r

Ď2230-3

Lug

Manufactured

BS5310 10-2-16 \$

Warehouse Location	Loc Oty	Loc Code	
Location			
Main Warehouse			
ST	7		
50306	5		
51568	2		
Main Warehouse			
ST176	5		
53881	5		
Main Warehouse			•
ST476	1		
53781	1		

	Dart	Aeros	pace	Ltd
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	•								
W/O:			W	ORK ORDER CHANG	GES			, 6 ,	•
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:		_ Date: _	
	Res	olution:						Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NCR)			
DATE	STEP	Description of NC	Initial		ction B	Verifica		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	С	Chief Eng	QC Inspector
							-		
					·				
									•

Picklist Print.

February 9, 2010 1:25:34 PM

Work Order ID: 56059

Parent Item:

K607-041

Parent Item Name:

Kit Basket D350-607-041

Comments:

IPP RevA: New issue DD verified by:EC

Manufactured



Start Date: 2/09/10

Required Date: 2/15/10

Page 2

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2324 Strut		Manufactured	No				Each	13.0000	(1.0000 	10-2-	16 8/	
				Warahan	100	Loc	Ωttr	Loc Code				

	<u>Warehouse</u>	Loc Qty	Loc Code	
	Location			
	Main Warehouse			
	ST	1	- Villadian	
	54576	1		
	Main Warehouse			
	ST521	12	·	
	55386	12	/	
No		f	107.0410 2.0000	
			10.2.16 S	

Warehouse Loc Oty Loc Code Location Main Warehouse ST 107.041 20.62 86.421

D2732

Rubber Extrusion

Cut qty 8 at 3.00" long -

Dart	Aer	ospa	ce Ltd
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	•								
W/O:			WC	RK ORDER CHANG	ES			, ,	•
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Re	esolution:						Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR))			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign &	Verifica		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section	n C	Chief Eng	QC Inspector
							<u> </u>		

Picklist Print

February 9, 2010 1:25:34 PM

Work Order ID: 56059

K607-041

Parent Item Name:

Kit Basket D350-607-041

Comments:

Parent Item:

IPP RevA: New issue DD verified by:EC

Start Date: 2/09/10

Required Date: 2/15/10

Page 3

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-12A		Purchased	No				Each	366.0000	5.0000	10-2-1	6 S	
				Warehou	<u>use</u>	Loc (<u>Qty</u>	Loc Code				
				Loca	ition							

Warehouse	<u>Lo</u>	c Qty	Loc Code			
Location						
Main Warehouse						
ST		366				
105143		1				
111605		13				
111929	111925	44		_5		
112314	•	300				
6071		8	/12×	,		
		Each	306.0000 8.0000		•	
				(0.916		

AN4-15A

Purchased No

Loc Qty Loc Code Warehouse Location Main Warehouse ST 306 113121 6 113538 100 113840 200 Each 0.0000

MAS114900463~ QSI 017 Sf

Purchased

No

126.0000

M1135 24 10.2-16 SP

Washer

W/0: 57	0059	WORK ORDER CHANG	GES	1994		· · · · · · · · · · · · · · · · · · ·	•
DATE	STEP	Perm. change	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/17	上上	Charge Qly to +12 per kit for ANY-150 Bolt. New \$51 9380 + 9342	4	0/02/18			To lochy

Part No: K607-041 PAR #:	_ Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR)						,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
	ATE STEP Description of NC			Corrective Action Section B		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector
		,						

Picklist Print

February 9, 2010 1:25:34 PM

Work Order ID: 56059

Parent Item:

K607-041

Parent Item Name:

Kit Basket D350-607-041

Comments:

IPP RevA: New issue DD verified by:EC

Start Date: 2/09/10

Required Date: 2/15/10

Start Qty: 1.00

Required Qty: 1.00

Component	Item	ID/
Item Name		

Replacement Mfg/ Item ID

Purch

Purchased

Bin Primary Item Location

No

Last Location

Route Seq ID Unit of Measure Hand

Each

Qty on

Remaining Qty To Pick Issued

Qty

Date **Issued**

Status

Page 4

MS21042L4

2,555.000 13.0000

Loc Qty	Loc Code	
2555		
6		
6		
184		
1359		13
1000		
0		
	2555 6 6 184 1359 1000	2555 6 6 184 1359 1000

Dart Aerospace Ltd

	•								•
W/O:			W	ORK ORDER CHANG	GES			,	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									· -
D - 1 N				,				10	
Part No		PAR #:							
	Re	solution:						Date:	
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NCR))			
DATE	STEP	Description of NC			Section B Verifica			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
				•					
			_						
4.									

DART AEROSPACE LTD.

ICA-D350-607 ICA Page 35 (36 blank) of 36

25.7 PARTS LIST

Revision:

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	Qty -041	Qty -043	Part Number	Description
	X		D350-607-041	HELI-UTILITY-BASKET
		Х	D350-607-043	HELI-UTILITY-BASKET
	2	5	- D2022-10 1	SPACER
		1	D2221-	BASKET BASE ASSEMBLY
d	4	4 🤇	D2230-1	LUG
- 2	4	4 /	D2230-3	CLAMP
		1	≠ D2258-200	LABEL
- (1	1 /		STRUT
		1	-D2332-041	PROP ASSEMBLY
			- D2512 -	BASKET LID ASSEMBLY
		1	-D2530	HANDLE WELDMENT
	2	2	-D2535-	SPRING
	2	2	-D2537-	BUSHING
DIE	-4-	4	D2856-400-720	ABRASION STRIP
	2	2 _	-D2931"	BUMPER
		1	D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
		1	D2989-043	BASKET LID ASSEMBLY (INSIDE)
		2	-AN3-16A	BOLT
	2_		-AN4-7A	BOLT
	~·· 5	5	AN4-12A	BOLT
	8	10	AN4-13A	BOLT
		7	AN4-22A	BOLT
			AN4-24A	BOLT
	4	4	_AN5-17A	BOLT
		2 -	MS20600AD4W3	RIVET (OR CR9163-4-3)
;	. 28 (2 0	6) 40 4	AN960JD416	WASHER -Z
	-2	2	AN960JD416L	WASHER
	A	4	AN960JD516	WASHER
		2 -	-AN960JD8	WASHER
	4	4	-AN970=4-	WASHER
		2 -	MS21042L3	NUT (OR MS21042-3)
	17(33)	22	MS21042L4	NUT (OR MS21042-4) -2 -2
	_4	4	-M 82104 2L5	NUT (OR MS21042-5)

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Page 15 (16 blank) of 16

25-00-00

Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANG	ES			, , ,	
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					į				
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DO	A:	Date: _	
	Re	solution:	Disposition	l:	_ QA: N/C C	losed: _		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	R)	-		
DATE	OTED	Description of NC	Corrective Action		on B	ication	on Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
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DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F REF CANADIAN STC: SH94-14 FAA STC: SR00213NY

REFERENCE ONLY

FOR THE FOLLOWING D350-607-XXX HELI-UTILITY-BASKET INSTALLATIONS, INSTALL THE D2732-030 RUBBER CUSHIONS UNDER THE D2230-1/-3 CLAMPS AS SHOWN IN FIGURE 1. THE D2856-400-720 ABRASION STRIPS HAVE BEEN REMOVED FROM THE D350-607-XXX HELI-UTILITY-BASKET KITS.

TABLE 1: D350-607-XXX KITS WITH D2732-030 RUBBER CUSHION

INSTALLATION	CHG NUMBER
D350-607-041	007 OR LATER
D350-607-043	004 OR LATER
D350-607-045	002 OR LATER
D350-607-047	002 OR LATER

AMEND PARTS LIST AS FOLLOWS:

REMOVE:

OH OLI CONTRO CONSIDE

1 1 5 57 5 - Landa - 14

Qty -041	Qty -043	Qty -045	Qty -047	PART NUMBER	DESCRIPTION
** X			e was	D350-607-041	HELI-UTILITY-BASKET
	Х			D350-607-043	HELI-UTILITY-BASKET
		Х	<u> </u>	D350-607-045	HELI-UTILITY-BASKET
			X	D350-607-047	HELI-UTILITY-BASKET
			17		
. 4	4	4	1.4	D2856-400-720	ABRASION STRIP
8	8*	8	8*	AN4-13A	BOLT

*NOTE: FOR D350-607-043/-047 INSTALLATIONS, QTY (2) AN4-13A BOLTS USED FOR INSTALLATION OF THE SPLIT LID ARE STILL INCLUDED

ADD:

DOME:

Qty -041	Qty -043	Qty -045	Qty -047	PART NUMBER	DESCRIPTION
X			1.1	D350-607-041	HELI-UTILITY-BASKET
	Х		(D350-607-043	HELI-UTILITY-BASKET
		Х	1	D350-607-045	HELI-UTILITY-BASKET
			Х	D350-607-047	HELI-UTILITY-BASKET
			,		
8	8	8	8 /	D2732-030	RUBBER CUSHION
_ ,			!		
~ 8	8	8	. 8	AN4-15A	BOLT

ISSUE NO .:

	CUSTO	MERS					
Α	NEW IS	SUE		MB	07.06.06		
REV.		C	ESCRIPTION	BY	DATE		
DESIGN	l	PH	DART AEROSE	PACE	LTD		
DRAWN	١,	PH	HAWKESBURY, ONTAI	RIO, CANA	ADA .		
CHECK	CHECKED		DRAWING NO.	REV. B			
MFG. AF	PPR.	N/A	DSI 9380		SHEET 1 OF 2		
APPRO	APPROVED /		TITLE		SCALE		
DE APPR. F			RUBBER CUSHION KIT				
DATE	07.1	1.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COMED OR COMMANACATED TO ANY OTHER PERSON WITHOUT WINTER PERMISSION FROM DAYT AEROSPACE LTD.				

PH

07.11.14

D2732-030 IS NOW STANDARD ON -041/-043/-045/-047:

DSI 9380-011 UPGRADE OPTION FOR PREVIOUS

Duit Aciospace Eta	Dart	Aeros	pace	Ltd
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	1	— - - -							
W/O:			WO	RK ORDER CHANG	ES			ζ ν. ι	•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			——————————————————————————————————————	-					
							į		
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	A :	_ Date: _	
	Re	esolution:	Disposition	1:	_ QA: N/C CI	A: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		on B	Verific	ation	Approval Chief Eng	Approval	
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	otion Sign & Date			on C	QC Inspector
							-		

 \angle

FOR D350-607-041 AT CHG 008, D350-607-043 AT CHG 005, AND D350-607-045/-047 AT CHG 003 AND SUBSEQUENT, THE INTENT OF DSI 9342 HAS BEEN INCORPORATED DURING MANUFACTURE. AMEND WEIGHT AND BALANCE AS OUTLINED BELOW. ALSO, THE PARTS LIST HAS BEEN AMENDED AS FOLLOWS:

QTY. -041	QTY. -043	QTY. -045	QTY. -047	PART NUMBER	DESCRIPTION
X				D350-607-041	HELI-UTILITY BASKET
	X			D350-607-043	HELI-UTILITY BASKET
		Х		D350-607-045	HELI-UTILITY BASKET (SHORT)
			Χľ	D350-607-047	HELI-UTILITY BASKET (SHORT)
				4	

IS:

K		1 1				
A 1	···1	1	1	AN4-12A	BOLT	
4	4	4	4	AN4-15A	BOLT	
28	40	30*	42*	AN960JD416	WASHER	

EXTRA WASHERS REQUIRED TO MOUNT LID ON BASE DUE TO INCREASED THICKNESS OF GUSSETS AT BOTH ENDS OF BASKET BASE. LOCATE WASHERS BETWEEN BASE HINGE PLATE AND D2022-101 SPACER, TYPICAL BOTH ENDS.

WAS:

				1	
5	5	5	5	AN4-12A	BOLT
28	40	28	40	AN960JD416	WASHER
1.45					

WEIGHT & BALANCE

INSTALLATION	WEIGHT	LA1	TERAL	LONGITUDINAL		
INSTALLATION	WEIGHT	ARM	MOMENT	ARM	MOMENT	
D350-607-041/-043 AT CHG 008/005	89.6 lb	±48 in	±4301 in-lb	135 in	±12096 in-lb	
HELI-UTILITY BASKET	40.6 kg	±1.22 m	±49.5 m-kg	3.43 m	±139.3 m-kg	
D350-607-045/-047 AT CHG 003	66.6 lb	±48 in	±3197 in-lb	135 in	±8991 in-lb	
HELI-UTILITY BASKET (SHORT)	30.2 kg	±1.22 m	±36.8 m-kg	3.43 m	±103.6 m-kg	

DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-0-01
BY: D. SHEPHERD (DE # 02)
DATE:
CERT. NO.: SH94-14
ISSUE NO.: 4

CANADA

DESIGN DRAWN	At B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	PH	DRAWING NO.	REV. B				
MFG. APPR.	N/A	DSI 9342	SHEET 4 OF 4				
APPROVED	-14	TITLE	SCALE				
DE APPR.		BASKET BASE WELD REPAIR	NTS				
DATE 09.0	4.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

Dart Aerospace Ltd

	•									
W/O:			WORK ORDER CHANGES					(
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								·.		
								:		
Part No:		PAR #:	Fault Categ	gory:	NCR: Yes	No DQ	A:	Date:		
					A: N/C Closed: Date:					
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCF	R)		<u> </u>	— <u> </u>	
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section I Action Description	Sign 8	Secti	Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng	Date	,				
,										
							<u>.</u>			
:										